

Work Order ID 65689

January 21, 2011 2:26:32 PM



Page 1

Item ID: D4278-047

Accept



Setup Start



Revision ID:

Stop



Item Name: Upper Rib Assembly-Straight

Start Date: 1/21/11 Start Qty: 1.00

Cust Item ID:

Required Date: 1/26/11 Req'd Qty: 1.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4278

C

100

Weld per dwg A/R S.S. rod Batch: 111585

0.00



Large Fab

Memo

0.00

Large Fab

1- Assemble bushing and weld as per dwg
2- Grind weld flush as per dwg

QC 11.01.26 (1x)

110

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

QC 11.01.26 (x1) 0 8E11/01/26

120

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

QC 11.01.26

(0)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 65689

January 21, 2011 2:26:32 PM



Page 2

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Stop



Start Date: 1/21/11 Start Qty: 1.00



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Required Date: 1/26/11 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



Packaging

Packaging

Identify as per dwg & Stock Location: *WA*

Memo

STOCK IN BASKET CELL

0.00

0.00

SAD

11-01-26

(1)

140



QC

Quality Control

QC21- Final Inspection - Work Order Release

Memo

0.00

0.00

11/01/27

MF

11-01-26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

January 21, 2011 2:26:31 PM

Page 1

Work Order ID: 65689

Parent Item: D4278-047

Parent Item Name: Upper Rib Assembly-Straight



Start Date: 1/21/11

Required Date: 1/26/11

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 10.11.12 new issue DD verf:EC
11.01.20 AS PER DWG REV.C DD verf:EC

IPP Rev:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D4021-9		Manufactured	No			100	Each	9.0000	4				
Bushing													

Pl 11-01-26

Location

Loc Qty

Loc Code

1A/WA	9	
56094	2	
63854	7	

D4277-1		Manufactured	No			100	Each	0.0000	1				
Rib													

365691 -> ④ Pl 11-01-26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

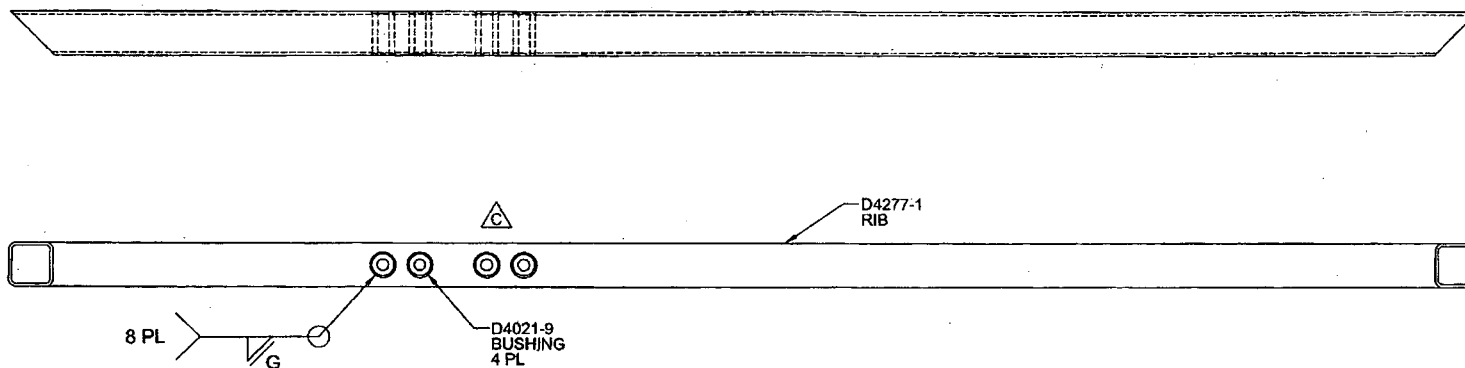
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	QTY	PART NUMBER	DESCRIPTION
	-047		
		D4278-047	UPPER RIB ASSY-STRAIGHT
1	4	D4021-9	BUSHING
2	1	D4277-1	RIB



D4278-047 UPPER RIB ASSY-STRAIGHT

NOTES:

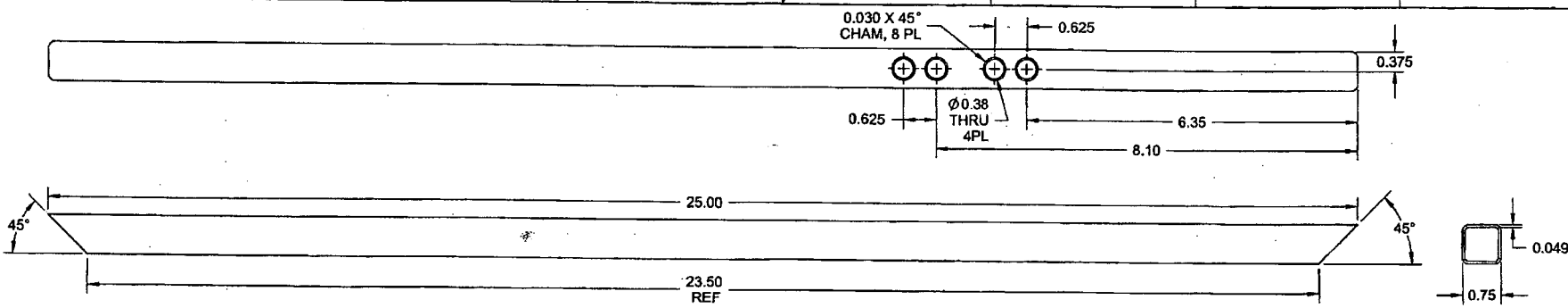
- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.95 lbs
- 8) WELD PER DART QSI 004.

RELEASED
2011-01-10

DESIGN	JPH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	SC		
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D4278	SHEET 4 OF 4
APPROVED		TITLE	SCALE
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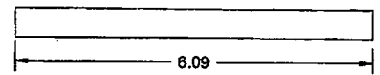
also 65689

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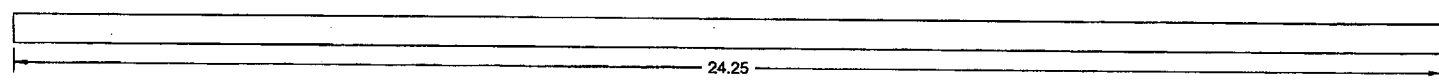
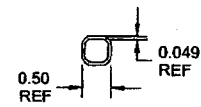


D4277-1 RIB

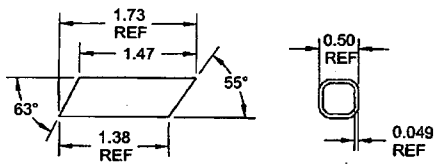
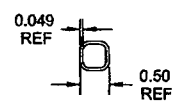
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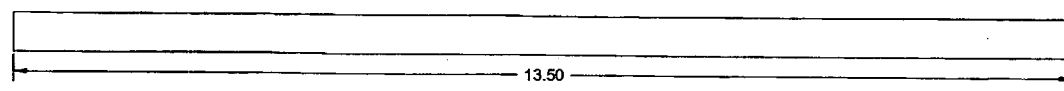
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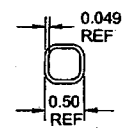
D4277-5 RIB



D4277-7 RIB







D4277-9 RIB



NOTES:

- 1) MATERIAL: -1: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.049 WALL
REF DART SPEC. M304TS0.750W.049
-3, -5, -7, -9: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.50 X 0.50 X 0.049 WALL
REF DART SPEC. M304TS0.500W.049
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: SEE ASSEMBLED WEIGHTS.

RELEASED
2011-01-18

DESIGN	JPH	DART AEROSPACE LTD	
DRAWN	SC	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D4277	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		RIBS	NTS
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8 7 6 5 4 3 2 1

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